

Work Order ID 58081



Page 1

April 22, 2010 2:28:05 PM

Item ID: D4049-5

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug, LH

4.0

Stop



Start Date: 4/22/10 Start Qty: 2.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date: 4/22/10 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4049	B

100



Bandsaw

Memo

cut blank 3.100" long

0.00

0.00

8/ 10/04/27

4 0

110



HAAS I

Memo

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA903

FOLIO REV: A

DWG REV: B

0.00

0.00

8/ 10/05/01

4 0

DEBURR

Work Order ID 58081

Page 2

April 22, 2010 2:28:06 PM

Item ID: D4049-5

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug, LH

Stop



Start Date: 4/22/10 Start Qty: 2.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC2- Inspect parts off machine FAI/FAIB

0.00

DB 10/05/01

4 0

QC

Quality Control

130



QC8- Inspect parts - second check

0.00

DT 10/05/03

4 0

QC

Quality Control

140



Chemical Conversion Coat per QSI005 4.1

0.00

(A) BL 10-5-3

HandFinish

Hand Finishing

Work Order ID 58081

April 22, 2010 2:28:06 PM



Page 3

Item ID: D4049-5

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug, LH

Stop



Start Date: 4/22/10 Start Qty: 2.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M114207

0.00

=) M

10/05/04

4 8

Powder Coating

Memo

POWDER COAT:
Start Time: 7:30 AM
Oven Temperature: 320° F
Finish Time: 8:00 AM

0.00

160



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

170



Identify as per dwg & Stock Location: 11

0.00

Packaging

Memo

0.00

Packaging

(D) BL 105-4.

6/15/11 C4

Work Order ID 58081

Page 4

April 22, 2010 2:28:07 PM

Item ID: D4049-5

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug, LH

Stop



Start Date: 4/22/10 Start Qty: 2.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

180



QC21- Final Inspection - Work Order Release

QC

Quality Control

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

10/05/06 JF

C2101515

Memo

Picklist Print

April 22, 2010 2:28:05 PM

Page 1

Work Order ID: 58081



Parent Item: D4049-5



Parent Item Name: Mounting Lug, LH

Start Date: 4/22/10

Required Date: 4/30/10

Comments: IPP REV:A NEW ISSUE 10-01-22 JLM VERIFIED BY:DD IPP
Rev:B as per dwg revA DD 10.02.18 verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased		No		100	f	47.0000	0.5476			

6061-T6 Bar 2.00 x 2.00

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT09	47
113006	20
113123	18
13085	9

0.5476

28 16/04/27

DART AEROSPACE LTD	Work Order:	58081
Description: Mounting Lug assy	Part Number:	D4049-5
Inspection Dwg: D4-049	Rev: B	Page 1 of 1

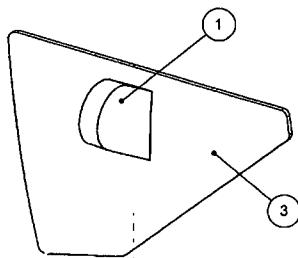
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

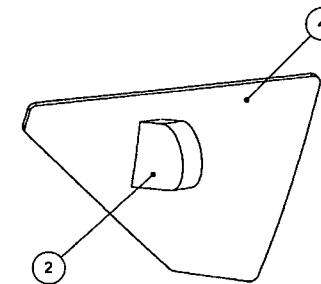
Measured by:	<i>L.S.</i>	Audited by:	<i>D.H.</i>	Prototype Approval:	N/A
Date:	10/05/01	Date:	10/05/03	Date:	N/A

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D4049-041	MOUNTING LUG ASSY, LH
		X	D4049-042	MOUNTING LUG ASSY, RH
1	1		D4049-1	LUG
2		1	D4049-2	LUG
3	1		D4049-3	MOUNTING PLATE, LH
4		1	D4049-4	MOUNTING PLATE, RH



D4049-041 MOUNTING LUG ASSY, LH



D4049-042 MOUNTING LUG ASSY, RH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58081

RJ10-4-22

RELEASED
R 2010-04-14
MP

B	80° WAS 83°, .033 WAS 0.55 & 2.10 WAS 2.50 (ZN C6-2)	RF	10.03.19
A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	DRAWING NO.	REV. B
MFG. APPR.	#	D4049	SHEET 1 OF 7
APPROVED	#	TITLE	SCALE
DE APPR.	#	MOUNTING LUG ASSY	NTS
DATE	10.03.19	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

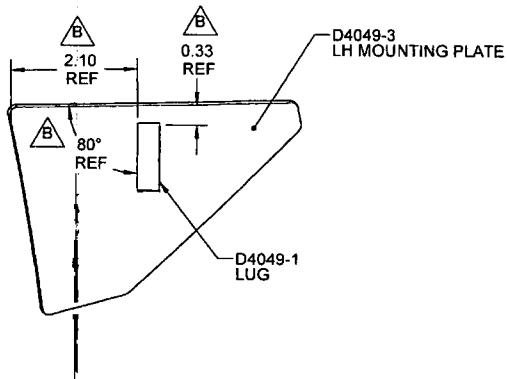
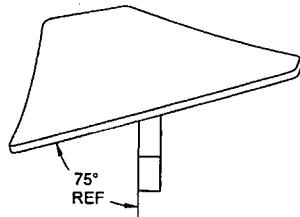
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

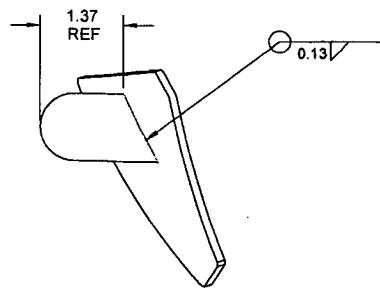
8 7 6 5 4 3 2 1

D

D



8 D4049-041 MOUNTING LUG ASSY, LH



W0 58081

RELEASED
2010-04-14
NP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DT9584

8 7 6 5 4 3 2 1

A

A

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	
MFG. APPR.	RF	D4049	REV. B
APPROVED	RF	SHEET 2 OF 7	SCALE
DE APPR.	RF	TITLE	NTS
DATE	10.03.19	MOUNTING LUG ASSY	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

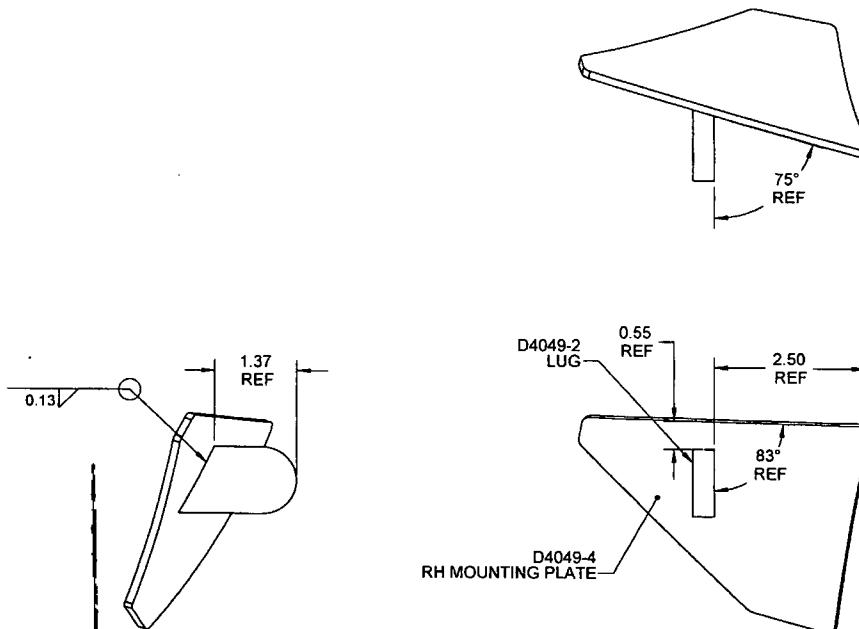
A

D

C

B

A



8 D4049-042 MOUNTING LUG ASSY, RH

W1038081

RELEASED
2010-04-14
NP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DT9583

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>TH</i>	DRAWING NO.
MFG. APPR.	<i>TH</i>	REV. B
APPROVED	<i>TH</i>	D4049
DE APPR.	<i>TH</i>	SHEET 3 OF 7
DATE	10.03.19	TITLE
		SCALE
		NTS
		MOUNTING LUG ASSY
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

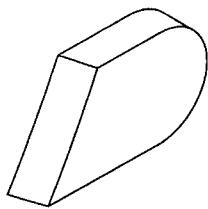
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

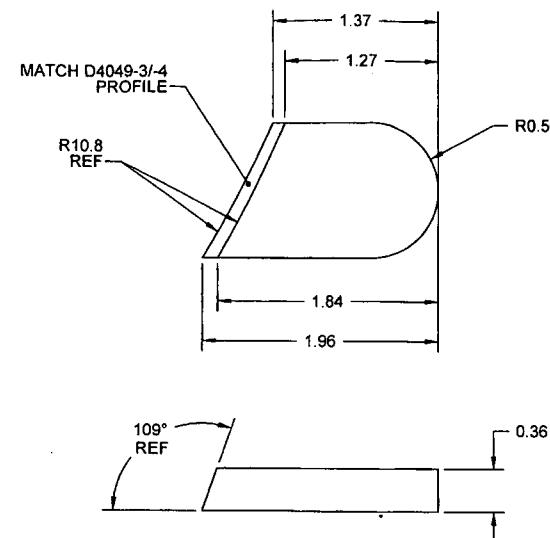
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D



C



B

D4049-1 LUG (SHOWN)
D4049-2 LUG (OPPOSITE)

RELEASED
2010-04-14
M

NOTES:

- 1) MATERIAL: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs

8 7 6 5 4 3 2 1

A

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	DRAWING NO.	REV. B
		D4049	SHEET 4 OF 7
MFG. APPR.	#	TITLE	SCALE
APPROVED	#	MOUNTING LUG ASSY	
DE APPR.	#		NTS
DATE	10.03.19	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

D

C

B

A

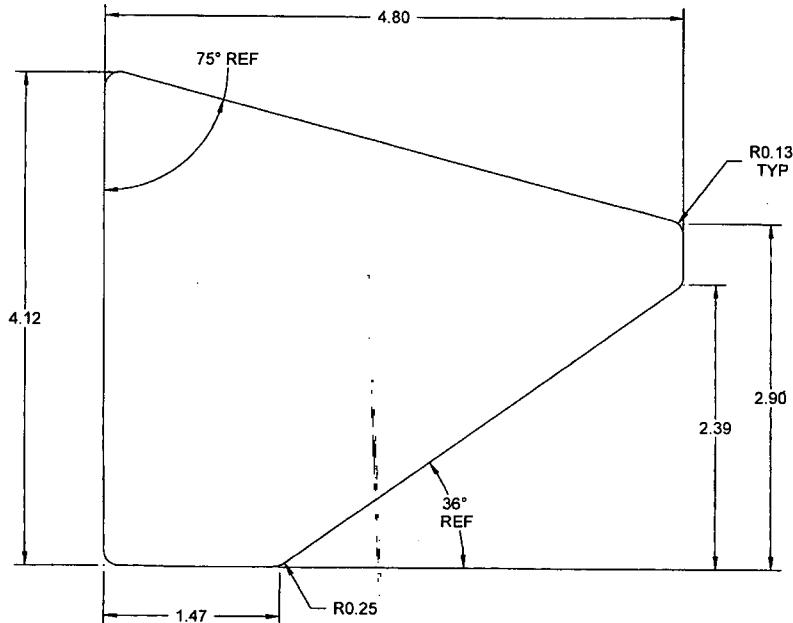
1 2 3 4 5 6 7 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

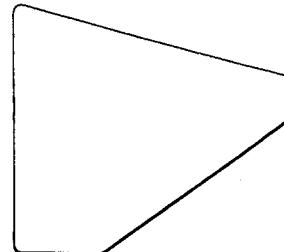
NOTE: Date & initial all entries



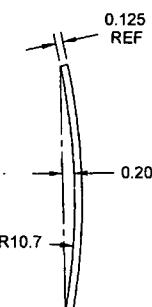
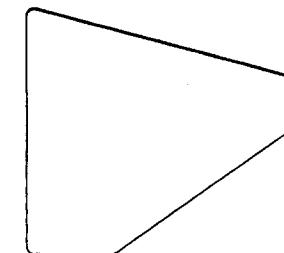
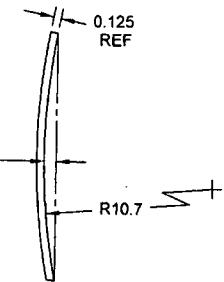
D4049-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH, 0.125" THICK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.46 lbs



D4049-3 MOUNTING PLATE, LH
(MAKE FROM D4049-3F FLAT PATTERN)



D4049-4 MOUNTING PLATE, RH
(MAKE FROM D4049-3F FLAT PATTERN)

RELEASED
R 2010-04-14

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. B	
MFG. APPR.		D4049	
APPROVED		SHEET 5 OF 7	
DE APPR.		TITLE	SCALE
DATE	10.03.19	MOUNTING LUG ASSY NTS	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

C

B

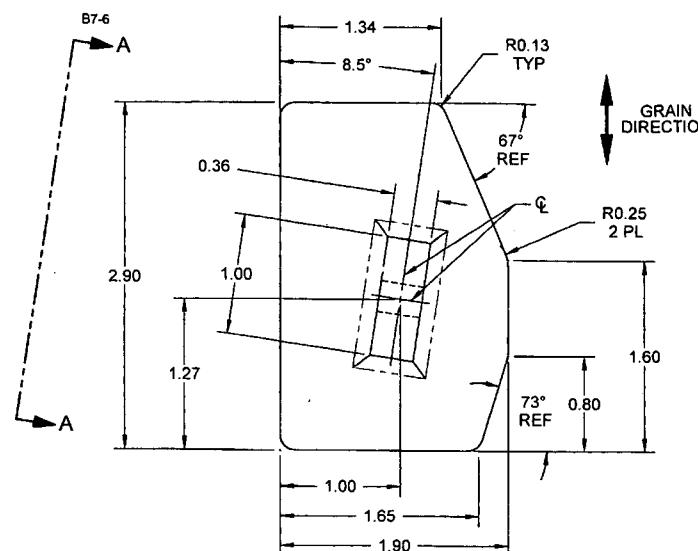
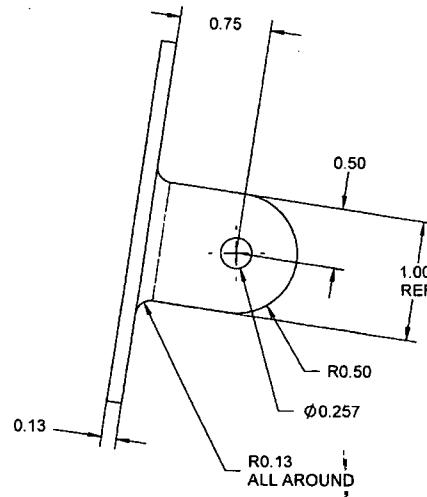
A

D

C

B

A



wb 38081

RELEASED
2010-04-14
NW

D4049-5 MOUNTING LUG, LH

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AMS-QQ-A-225/8 OR AMS-QQ-A-200/8 OR ASTM B211 OR B221
PER DART SPEC MG061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	DRAWING NO.
		D4049
MFG. APPR.	RF	REV. B
APPROVED	RF	SHEET 6 OF 7
DE APPR.	RF	TITLE
DATE	10.03.19	SCALE
		NTS
		MOUNTING LUG ASSY

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8

7

6

5

4

3

2

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

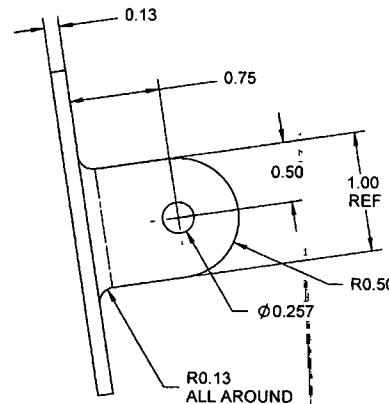
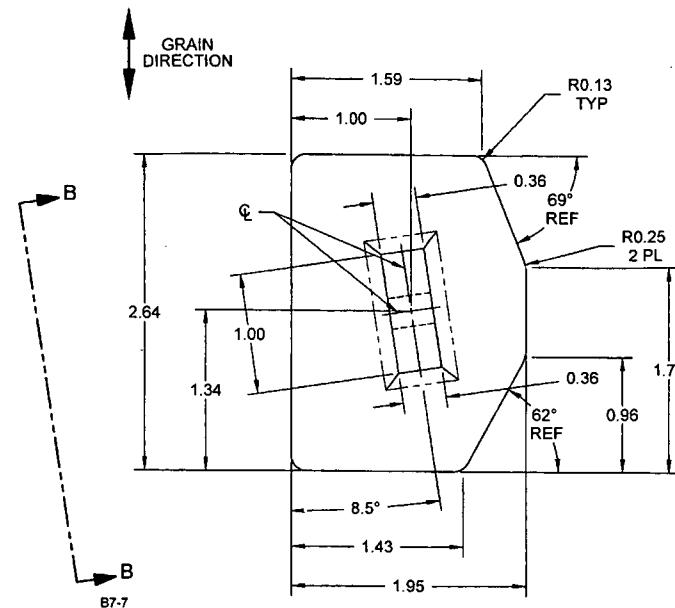
8 7 6 5 4 3 2 1

D

C

B

A

VIEW B-B B5-7D4049-8 MOUNTING LUG, RH

W058081

RELEASED
2010-04-14
NP

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AMS-QQ-A-225/8 OR AMS-QQ-A-200/8 OR ASTM B211 OR B221
PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-8" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. B
MFG. APPR.		D4049
APPROVED		SHEET 7 OF 7
DE APPR.		TITLE
DATE	10.03.19	SCALE
		NTS
		MOUNTING LUG ASSY

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8 7 6 5 4 3 2 1

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries